

Date: Tuesday, 1/23/2007 8:29:29 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : CLAMP  
 Job Number : 30386  
 Estimate Number : 10623  
 P.O. Number : N/A Part Number : D2947  
 This Issue : 1/23/2007 S.O. No. : N/A Drawing Number : D2947 REV A1  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : 1/23/2007 Type : SMALL / MED FAB Drawing Revision : A1  
 Previous Run : 29835 Material : N/A  
 Due Date : 2/5/2007 Qty: 250 Um: Each  
 Written By :  
 Checked & Approved By :  
 Comment : Est: A 00.01.14 New issue EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S16GA 304/316 .063 Sheet



Comment: Qty.: 0.0504 sf(s)/Unit Total: 12.6000 sf(s)

304/316 .063 Sheet

7 batch: M101873

(250)

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2947

Dwg Rev: A1

Prog Rev: A1

MA 07 01 25

(250)

2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MA 07 01 25

(250)

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

MA 07/01/29

(250)

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Deburr any rough edges

2- Bend as per Dwg D2947

N/A

ME

07-02-08

(250)

Issue P.O for forming 3077 &  
 CFI

C 207/02/09 (250)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/03/07  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/03/07	G.O	2 parts missing Qc it possibly lost in house.	QS1042	Looked in No Find. Qty to be 248	07/03/07 FF 07-03-07	07/03/07	QS1042	07/03/07

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLAMP

Job Number: 30386

Part Number: D2947

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 07-03-08

248

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

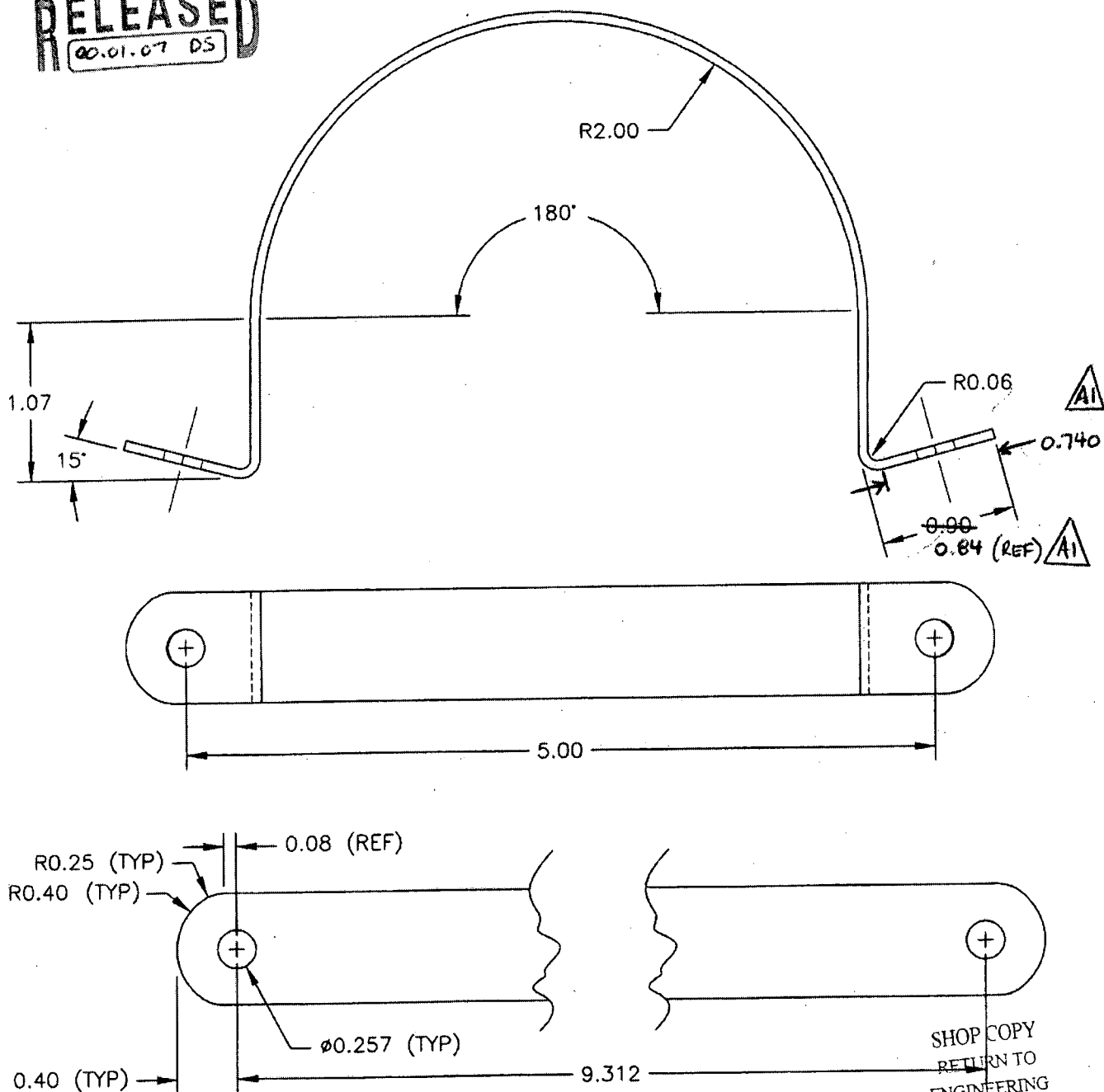
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2947	REV. A SHEET 1 OF 1
DATE 00.01.06		TITLE CLAMP	SCALE 1:1
A	00.01.06	NEW ISSUE	

RELEASED  
00.01.07 DS



D2947 FLAT PATTERN

MATERIAL: AISI 304/316 SS 0.063 THICK x 0.75 WIDE  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

WORK ORDER  
NO. 30386

AI 01.09.07 ADD 0.740 DIMENSION; 0.84 WAS 0.90



# CERTIFICATE OF COMPLIANCE CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE  
POINTE CLAIRE, QC  
H9R 1A1

**DART AEROSPACE LTD**  
1270 ABERDEEN ST.  
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO.	5	OUR JOB NO	J0157554	SHIPPING MEMO	0358106	
ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUE
	350 PCS	PO00003072	D2947	A	CLAMP	A
MATERIAL	SUPPLIED BY		MAT. REL. NO.			
SST 304 / 316	SUPPLIED BY DART AEROSPACE		P.O # 3077			

	PROCESS	PROCESSOR	RELEASE NOTE #
1	FIRST ARTICLE INSPECTION REPORT ON FILE	GFI	CONFORMS
2			
3			
4			
5			
6			
7			
8			
9			

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 20 FEBRUARY 2007

G.F.I. Q.C. REP.

B. SAMIEC



*A Duplicate \**

**Dart Aerospace Ltd.**

Date: Thursday, 15/03/2007 7:17:47 AM

User: Linda Lacelle

**JOB HISTORY : DETAIL**

<b>Job Number</b>	: 30386	<b>Customer</b>	: Dart Helicopters Services
<b>Estimate Number</b>	: 10623	<b>DWG Name</b>	: CLAMP
<b>Purchase Order #</b>	:	<b>Part Number</b>	: D2947
<b>Complete Date</b>	: 08/03/2007 10:23:02	<b>DWG Number</b>	: D2947 REV A1
		<b>Rev.</b>	: A1

<b>DUE DATE</b>	<b>ORDERED</b>	<b>DELIVERED</b>
05/02/2007	250	248

<b>1.0 M304S16GA-304/316 .063 Sheet</b>		<b>INVENTORY ITEM</b>	
<b>DATE</b>	<b>EMPLOYEE</b>	<b>TYPE</b>	<b>Qty</b>
26/01/2007	MURD02: Murdoch, Matthew	M304S16GA	12.600
<b>Subtotal:</b>	QTD:	0 CTD:	13
			\$90.03

Lot # 101873 Qty. 13

<b>2.0 WATER JET</b>		<b>Internal Operation</b>	
<b>DATE</b>	<b>EMPLOYEE</b>	<b>TYPE</b>	<b>Qty</b>
25/01/2007	MURD02: Murdoch, Matthew	Run	0.000
25/01/2007	MURD02: Murdoch, Matthew	Run	0.000
26/01/2007	MURD02: Murdoch, Matthew	Run	250.000
<b>Subtotal:</b>	QTD:	250 CTD:	0
			8.25
			\$912.17

<b>5.0 SMALL FAB 1</b>		<b>Internal Operation</b>	
<b>DATE</b>	<b>EMPLOYEE</b>	<b>TYPE</b>	<b>Qty</b>
01/02/2007	MYRE02: Myre, Henri	Run	250.000
02/02/2007	MYRE02: Myre, Henri	Run	250.000
07/02/2007	BOUC01: Boucher, Sylvie	Run	0.000
08/02/2007	FAUT01: Fauteux, Melanie	Run	0.000
09/02/2007	FAUT01: Fauteux, Melanie	Run	0.000
09/02/2007	FAUT01: Fauteux, Melanie	Run	250.000
<b>Subtotal:</b>	QTD:	750 CTD:	0
			8.93
			\$530.08

<b>7.0 SMALL FAB 1</b>		<b>Internal Operation</b>	
<b>DATE</b>	<b>EMPLOYEE</b>	<b>TYPE</b>	<b>Qty</b>
05/03/2007	DROU02: Drouin, Steven	Run	250.000
07/03/2007	BOUC01: Boucher, Sylvie	Run	0.000
<b>Subtotal:</b>	QTD:	250 CTD:	0
			2.60
			\$145.73

<b>9.0 OUTSIDE SERVICE</b>		<b>Sub-contr./External OP.</b>	
<b>DATE</b>	<b>EMPLOYEE</b>	<b>TYPE</b>	<b>Qty</b>
26/02/2007			250.000
<b>Subtotal:</b>	QTD:	0 CTD:	250
			\$487.50

VC-GFI P.O.: PO00003077

	<b>TIME</b>	<b>COST</b>
Machine Time:	19.94	\$1251.90
Labor:	19.78	\$336.08
Sub-contract (external Op.):		\$487.50
INVENTORY ITEM:		\$90.03
SUB-COMPONENT (SUB-JOB):		\$0.00
<b>Total:</b>		\$2165.51

COST PER UNIT: \$8.73